

(131 °F) multiplied by a safety factor of 1.5. This pressure must be determined on the basis of the IBC being filled and closed to no more than 98 percent capacity at 15 °C (60 °F);

(B) If absolute pressure (vapor pressure of the hazardous material plus atmospheric pressure) is used, 1.5 multiplied by the vapor pressure of the hazardous material at 55 °C (131 °F) minus 100 kPa (14.5 psi). If this method is chosen, the hydrostatic test pressure applied must be at least 100 kPa gauge pressure (14.5 psig); or

(C) If absolute pressure (vapor pressure of the hazardous material plus atmospheric pressure) is used, 1.75 multiplied by the vapor pressure of the hazardous material at 50 °C (122 °F) minus 100 kPa (14.5 psi). If this method is chosen, the hydrostatic test pressure applied must be at least 100 kPa gauge pressure (14.5 psig); or

(ii) Twice the greater of: (A) The static pressure of the hazardous material on the bottom of the IBC filled to 98 percent capacity; or

(B) The static pressure of water on the bottom of the IBC filled to 98 percent capacity.

(e) *Criteria for passing the test(s).* (1) For metal IBCs, subjected to the 65 kPa (9.4 psig) test pressure specified in paragraph (d)(1) of this section, there may be no leakage or permanent deformation that would make the IBC unsafe for transportation.

(2) For metal IBCs intended to contain liquids, when subjected to the 200 kPa (29 psig) and the 250 kPa (36 psig) test pressures specified in paragraphs (d)(2) and (d)(3) of this section, respectively, there may be no leakage.

(3) For rigid plastic IBC types 21H1, 21H2, 31H1, and 31H2, and composite IBC types 21HZ1, 21HZ2, 31HZ1, and 31HZ2, there may be no leakage and no permanent deformation which renders the IBC unsafe for transportation.

[Amdt. 178–103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45185, 45386, Aug. 28, 2001]

§ 178.815 Stacking test.

(a) *General.* The stacking test must be conducted for the qualification of all IBC design types intended to be stacked.

(b) *Special preparation for the stacking test.* (1) All IBCs except flexible IBC de-

sign types must be loaded to their maximum permissible gross mass.

(2) The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* (1) *Design Qualification Testing.* All IBCs must be placed on their base on level, hard ground and subjected to a uniformly distributed superimposed test load for a period of at least five minutes (see paragraph (c)(5) of this section).

(2) Fiberboard, wooden and composite IBCs with outer packagings constructed of other than plastic materials must be subject to the test for 24 hours.

(3) Rigid plastic IBC types and composite IBC types with plastic outer packagings (11HH1, 11HH2, 21HH1, 21HH2, 31HH1 and 31HH2) which bear the stacking load must be subjected to the test for 28 days at 40 °C (104 °F).

(4) For all IBCs, the load must be applied by one of the following methods:

(i) One or more IBCs of the same type loaded to their maximum permissible gross mass and stacked on the test IBC;

(ii) The calculated superimposed test load weight loaded on either a flat plate or a reproduction of the base of the IBC, which is stacked on the test IBC.

(5) *Calculation of superimposed test load.* For all IBCs, the load to be placed on the IBC must be 1.8 times the combined maximum permissible gross mass of the number of similar IBCs that may be stacked on top of the IBC during transportation.

(d) *Periodic Retest.* (1) The package must be tested in accordance with paragraph (c) of this section; or

(2) The packaging may be tested using a dynamic compression testing machine. The test must be conducted at room temperature on an empty, unsealed packaging. The test sample must be centered on the bottom platen of the testing machine. The top platen must be lowered until it comes in contact with the test sample. Compression must be applied end to end. The speed of the compression tester must be one-half inch plus or minus one-fourth inch per minute. An initial preload of 50 pounds must be applied to ensure a

definite contact between the test sample and the platens. The distance between the platens at this time must be recorded as zero deformation. The force "A" then to be applied must be calculated using the applicable formula:

Liquids: $A = (1.8)(n - 1) [w + (s \times v \times 8.3 \times .98)] \times 1.5$;

or

Solids: $A = (1.8)(n - 1) [w + (s \times v \times 8.3 \times .95)] \times 1.5$

Where:

A = applied load in pounds.

n = maximum number of IBCs being stacked during transportation.

w = maximum weight of one empty container in pounds.

s = specific gravity (liquids) or density (solids) of the lading.

v = actual capacity of container (rated capacity + outage) in gallons.

and:

8.3 corresponds to the weight in pounds of 1.0 gallon of water.

1.5 is a compensation factor converting the static load of the stacking test into a load suitable for dynamic compression testing.

(e) *Criteria for passing the test.* (1) For metal, rigid plastic, and composite IBCs, there may be no permanent deformation, which renders the IBC unsafe for transportation, and no loss of contents.

(2) For fiberboard and wooden IBCs, there may be no loss of contents and no permanent deformation, which renders the whole IBC, including the base pallet, unsafe for transportation.

(3) For flexible IBCs, there may be no deterioration, which renders the IBC unsafe for transportation, and no loss of contents.

(4) For the dynamic compression test, a container passes the test if, after application of the required load, there is no permanent deformation to the IBC, which renders the whole IBC, including the base pallet, unsafe for transportation; in no case may the maximum deflection exceed one inch.

[75 FR 5397, Feb. 2, 2010]

§ 178.816 Topple test.

(a) *General.* The topple test must be conducted for the qualification of all flexible IBC design types.

(b) *Special preparation for the topple test.* The flexible IBC must be filled to

not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* A flexible IBC must be toppled onto any part of its top upon a rigid, non-resilient, smooth, flat, and horizontal surface.

(d) *Topple height.* For all flexible IBCs, the topple height is specified as follows:

(1) Packing Group I: 1.8 m (5.9 feet).

(2) Packing Group II: 1.2 m (3.9 feet).

(3) Packing Group III: 0.8 m (2.6 feet).

(e) *Criteria for passing the test.* For all flexible IBCs, there may be no loss of contents. A slight discharge (e.g., from closures or stitch holes) upon impact is not considered to be a failure, provided no further leakage occurs.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.817 Righting test.

(a) *General.* The righting test must be conducted for the qualification of all flexible IBCs designed to be lifted from the top or side.

(b) *Special preparation for the righting test.* The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, with the load being evenly distributed.

(c) *Test method.* The flexible IBC, lying on its side, must be lifted at a speed of at least 0.1 m/second (0.33 ft/s) to an upright position, clear of the floor, by one lifting device, or by two lifting devices when four are provided.

(d) *Criterion for passing the test.* For all flexible IBCs, there may be no damage to the IBC or its lifting devices which renders the IBC unsafe for transportation or handling.

[Amdt. 178-103, 59 FR 38074, July 26, 1994, as amended at 66 FR 45386, Aug. 28, 2001]

§ 178.818 Tear test.

(a) *General.* The tear test must be conducted for the qualification of all flexible IBC design types.

(b) *Special preparation for the tear test.* The flexible IBC must be filled to not less than 95 percent of its capacity and to its maximum net mass, the load being evenly distributed.

(c) *Test method.* Once the IBC is placed on the ground, a 100-mm (4-inch) knife score, completely penetrating the